Monday, 7/9/2007 11:46:59 AM User: Kim Johnston : CU-DAR001 Dart Helicopters Services Customer Job Number : 33359 **Estimate Number** : 12662 : NIA P.O. Number : 7/9/2007 This Issue Prsht Rev. First Issue Previous Run Written By Checked & Approved By Comment **Additional Product** Job Number: Seq. #: Machine Or Operation: 1.0 F60029 Comment: Qty.:

Process Sheet

Drawing Name

: CABIN FLOOR PROTECTOR

: D35752

Part Number Drawing Number

D3575 REV.A

Project Number **Drawing Revision** : N/A

Material Due Date

: 7/13/2007

Each



Description:

lexan grey

16,0000 sf(s)/Unit

Total:

: SMALL /MED FAB

New Issue 07-01-22

48.0000 sf(s)

EC

F60029 lexan sheet Batch: M 103 106

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3575

Dwg Rev: ____

Prog Rev: ____

2-Deburr if necessary

B

3.0 QC2



67-07-12 Æ Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK



40

Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1



5.0

SMALL FAB 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.



Dart Aerospace Ltd

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				1			
				i i			
				· .		7	4 /

			1				
Part No:	PAR #:	Fault Category:	NCR: Yes	No DQA	1: D	Date: 💇	107/05
			QA:	N/C Closed	l:	Date:	

NCR:	WORK ORDER NON-CONFORMANCE (NCR							
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto
					1			
					1			
					<u>: </u> 			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:46:59 AM User: Kim Johnston **Process Sheet** Drawing Name: CABIN FLOOR PROTECTOR Customer: CU-DAR001 Dart Helicopters Services Part Number: D35752 Job Number: 33359 Job Number: Seq. #: Description: Machine Or Operation: INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP 7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES		1				
DATE	STEP	PROCEDURE CHANGE	В	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				-				
				:				
		,		1				
Part No	•	PAR #: Fault Category: No	CR: Y	es l	No DQ	A:	Date:	<u></u>

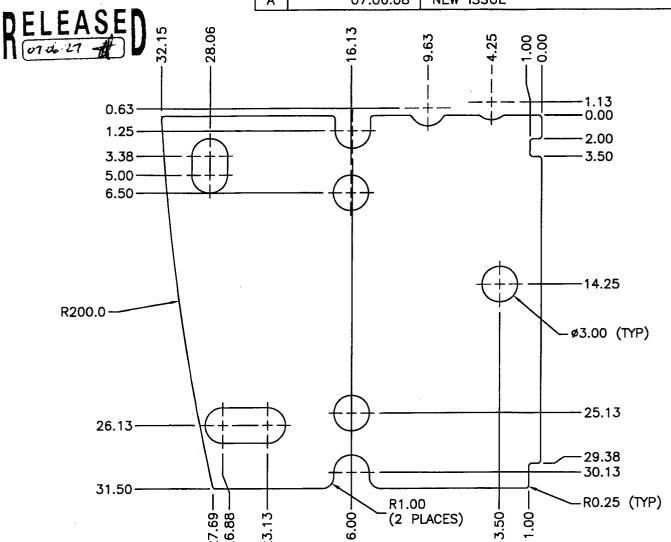
QA: N/C Closed: ____ Date: ____

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Varification	A	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspector
				·			·	
					<u> </u>			
			·			·		

NOTE: Date & initial all entries







D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, SHOP COPY TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) RETURN TO

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

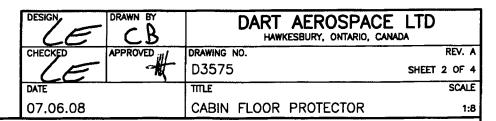
ENGINEERING

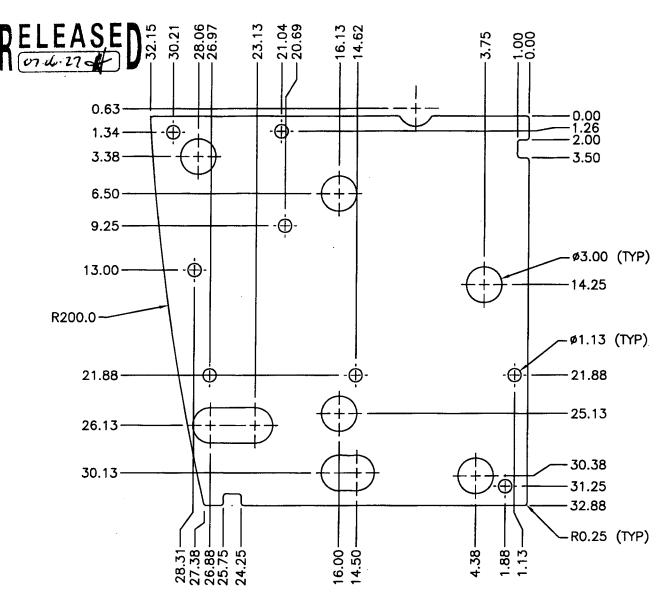
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ED COPY SUBJECT TO AMENDMENT ON SMOOTH SIDE OF PART WITHOUT NOTICE
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

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D3575-3 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK COPY TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) RETURN TO
- 2) FINISH: NONE

ENGINEERING

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

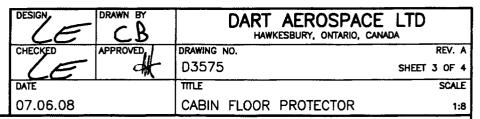
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INKNMARKER SUBJECT TO AMENDMENT

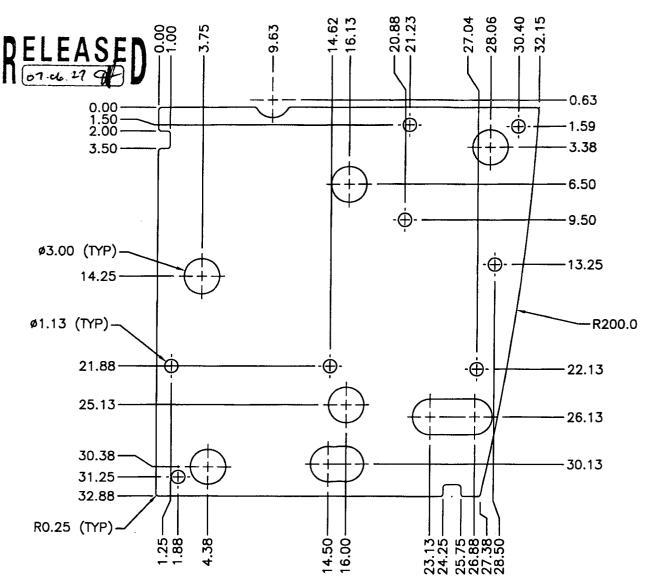
 5) ALL DIMENSIONS ADD IN MICHIGAN WITHOUT NOTICE WORK ORDER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

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D3575-4 CABIN FLOOR PROTECTOR

NOTES:

1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 STATER OF Y RETURN TO TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)

2) FINISH: NONE

ENGINEERING

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY

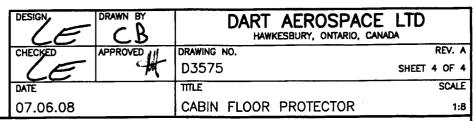
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INKSIMARKER ENDINENT WITHOUT NOTICE ON SMOOTH SIDE OF PART WORK ORDER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

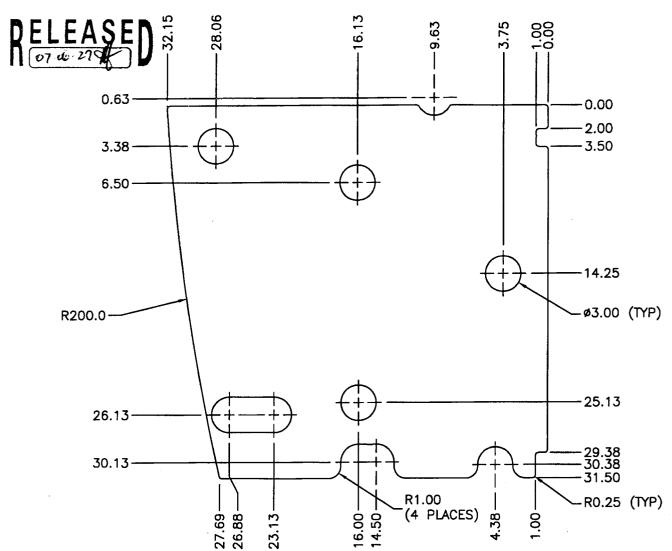
7) CHECK PER TEMPLATE DT8968

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D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, SHOP COPY TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)

2) FINISH: NONE

RETURN TO

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ENGINEERING

4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER LED COPT ON SMOOTH SIDE OF PART

SUBJECT TO AMENDMENT WITHOUT NOTICE

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

7) CHECK PER TEMPLATE DT8969

NO

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DART AEROSPACE LTD	Work Order:	33359
Description: CLBIN FLOOR PROTECTOR	Part Number:	D3575-2
Inspection Dwg: Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	F	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	4- 1030	1.75	₩			
3.38	4/030	3.38	*			
2,00	+/030	5,00	*			
6.50	+/030	6.50	¥			
26.13	+/ 030	26.13	*			
31.50	+/030	31.50	*			
3.00	+/030	9.∞	*			
3.50	1/- ,030	3,50	*			
14,25	+/630	14.25	*			
Ø 3.00	1/m. 0170001	3.00	*			
25.13	4/030	25.13	*			
24.38	4/030	7438	*			
30.3	+/030	30.13	*			•
				-		
				-		
				-		
						•

Measured by:	ıD.	Audited by:	Prototype Approval:	
	145	- 4	Deter	
Date:	67-07-12	Date: UTUTIZ	Date:	
52.0.	01-01-17	570712	L	

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/RF	

DART AEROSPACE LTD	Work Order:	33359
Description: CABIN FLOOR PROTECTOR	Part Number:	D 3575-2
Inspection Dwg: Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

¥	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.69	4- ,030	97,69	×			
26.88	4/030	26.88	*			
23.13	7030	23,13	X			
16.00	4630	16.00	∀ 4			
3.50	41030	3.50	¥			
00.7	4030	1.00	*			
32.15	+/030	35'12	*			
28.06	4/030	28.06	*			
16.13	4/- 630	16,3	¥		·	
9.63	4/630	9.63	K			
4.25	4/- 030	4.75	×			
1.00	+/- 1036	1.66	¥			
				•		
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		3				1

Measured by: 🛱	Audited by:	20	Prototype Approval:	
Date: 07-07-13	Date:	57/07/12	Date:	

Rev	Date Change		Revised by	Approved	
A		New Issue		KJ/RF	